DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

99.28 File #:

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-018628 Address: 333 Burma Road **Date Inspected:** 17-Dec-2010

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes Mr. Geng Wei No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component: OBG** Segment

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing (MT) – NWIT Document No's: 007816

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment 13 Anchor Plate. The weld designations reviewed are as follows:

- 1. AP3005-001-104, 105, 117, 118, 131, 132, 115, 116, 124
- 2. AP3005-001-125, 128, 129, 007, 008, 016, 019, 024, 025
- 3. AP3005-001-036, 037, 048, 049, 056, 057, 064, 065
- 4. AP3005-001-072, 073, 084, 085, 090, 092, 096, 097
- 5. AP3006-001-012, 013, 020, 021, 026, 029, 030, 034, 037
- 6. AP3006-001-142, 143, 049, 050, 061, 062, 065, 066, 069, 070
- 7. AP3006-001-074, 075, 078, 079, 082, 083, 096, 097, 100
- 8. AP3006-001-101, 124, 125, 076, 077, 080, 081, 120
- 9. AP3007-001-010, 011, 018, 019, 022, 023, 031
- 10. AP3007-001-033, 042, 043, 046, 047, 050, 051
- 11. AP3007-001-058, 059, 066, 067, 060, 064, 061, 065
- 12. AP3007-001-089, 090, 098, 099, 110, 111, 148, 149, 150

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint OBW13AD-002 located on Side Plate to Edge plate of the OBG Segment 13BW and 13CW. ZPMC Welder is identified as 201583. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2133-ESAB.

This QA observed ZPMC UT personnel performing Ultrasonic Testing on panel point 118 floor beam to floor beam top butt joint. The weld number is identified as SEG3013Q-027. See the attaché picture.

Shielded Metal Arc Welding (SMAW) repair welding of weld joint DP3104-001-248 located on deck panel to deck panel splice joint of OBG Segment 13CE. ZPMC Welder is identified as 066261. ZPMC Quality Control (QC) is identified as Mr. Zhang Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – FCM – Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2400.

SMAW repair welding of weld joint DP3106-001-042 located on deck panel to deck panel splice joint of OBG Segment 13CE. ZPMC welder is identified as 070007. ZPMC Quality Control (QC) is identified as Mr. Zhang Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – FCM-Repair, which is used as per Welding Repair Report (WRR) B-WRR-18705.

SMAW repair welding of weld joint DP3105-001-045 located on deck panel to deck panel splice joint of OBG Segment 13CE. ZPMC welders are identified as 044830 and 037997. ZPMC Quality Control (QC) is identified as Mr. Zhang Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – FCM-Repair, which is used as per Welding Repair Report (WRR) B-WRR-18697.

FCAW welding of weld joint SEG3014B-052 located on Floor Beam to Edge Plate of the OBG Segment 13BW ZPMC Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2232-ESAB.

FCAW welding of weld joint SEG3015B-106 located on Floor Beam joint at panel point 124.5 of the OBG Segment 13CW. ZPMC Welder is identified as 067876. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2132-ESAB.

FCAW welding of weld joint SEG3015B-109 located on Floor Beam joint at panel point 124.5 of the OBG Segment 13CW. ZPMC Welder is identified as 067876. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2133-ESAB.

SMAW welding of weld joint SEG3015D-238, 239 and 240 located on Floor Beam (FB3208) at PP121 of the OBG Segment 13BW. ZPMC Welder is identified as 045276. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-P-2214.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.





Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar, Vibin	Quality Assurance Inspector
Reviewed By:	Patel, Hiranch	QA Reviewer